

Work Order ID 144263 - 2

144263

Page 1

April 11, 2016 8:11:12 AM

Item ID: DSI 9464-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube Tuning

Start Date: 4/11/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/19/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date: 20160411 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3955	A		DAS	8					
DSI 9464	B		3-89						

100

Document Control

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP DSI 9464-011
CHG001

DAS
28
9-89

APR 21 2016

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

X/1

DAS
27
9-89

APR 19 2016

Work Order ID 144263

April 11, 2016 8:11:12 AM

144263

Page 2

Item ID: DSI 9464-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Skidtube Tuning

Stop ***NS2***

Start Date: 4/11/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/19/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									
130		0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP DSI 9464-011 Location : FG122								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

DAS
28
9-89

APR 21 2016

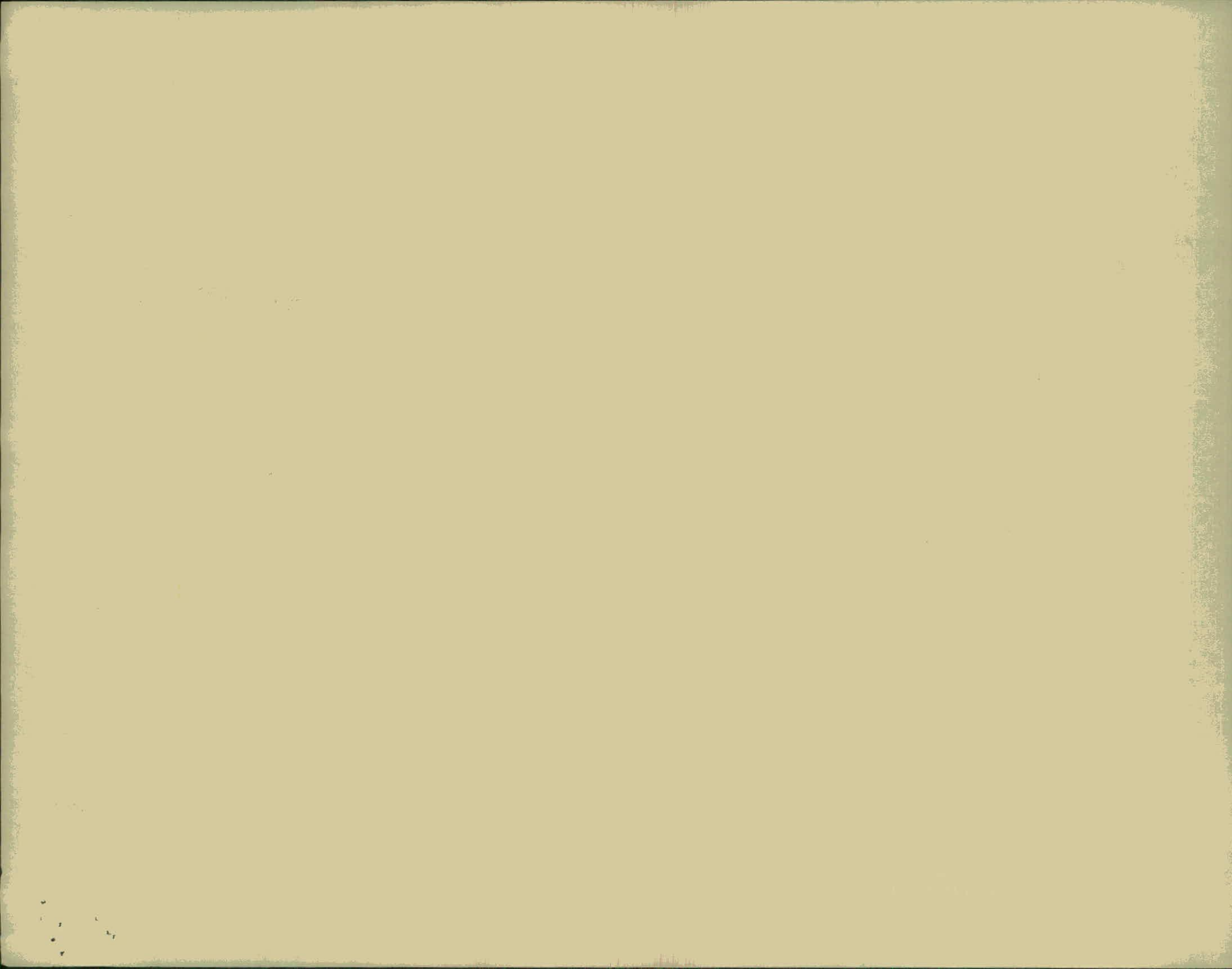
DAS
28
9-89

APR 21 2016

MCS

APR 21 2016

MC
10-4-21



April 11, 2016 8:11:15 AM

144263

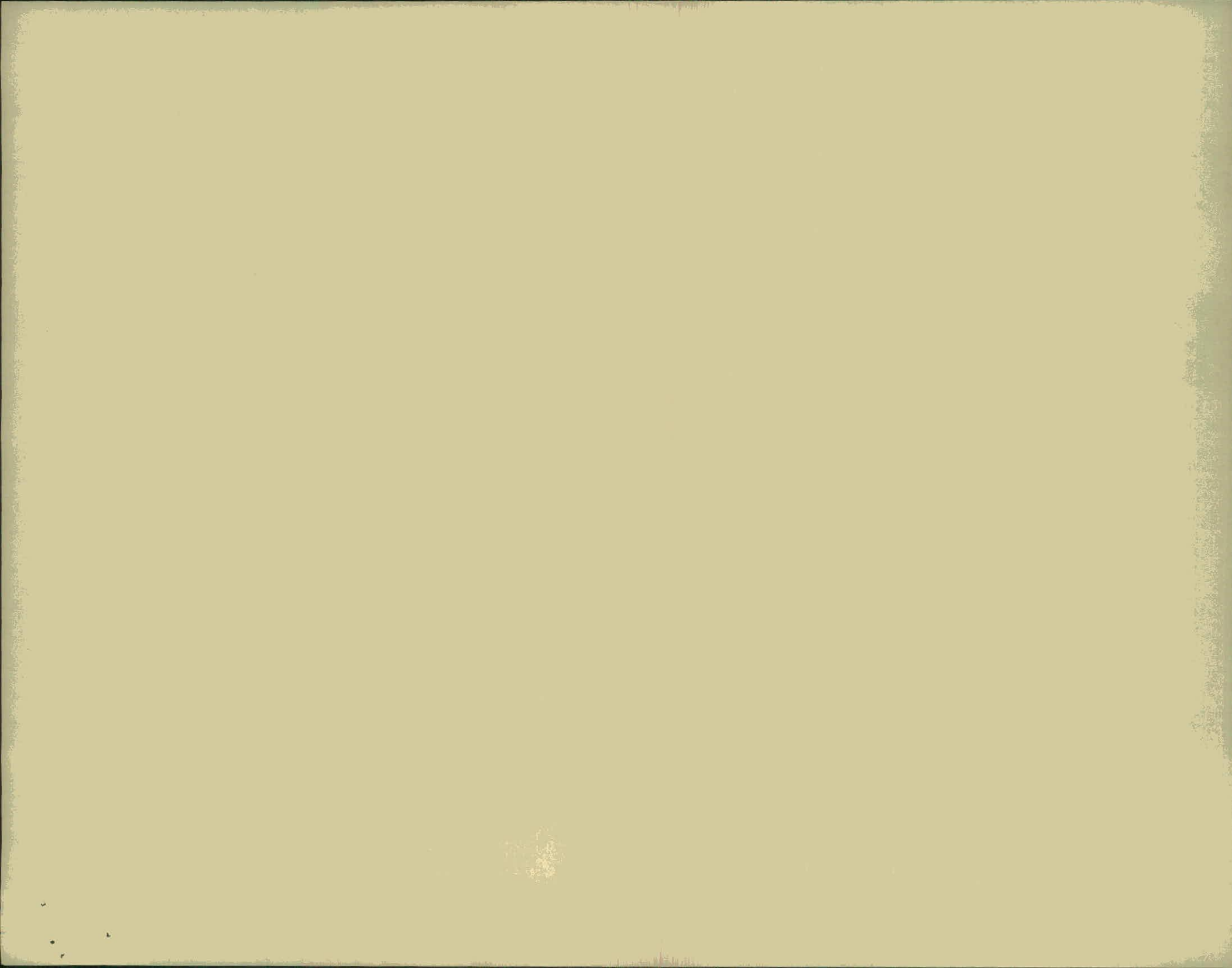
DSI 9464-011

Required Qty: 1.00

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3955-041		Manufactured	No			110	Each	5.0000	2	2			DAS 8 9-89
D3955-041													
Doubler Assembly													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST064			5						
					144063		5						DAS 8 9-89
D3955-3		Manufactured	No			110	Each	2.0000	2	24			DAS 8 9-89
D3955-3													
Cover Plate													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST063			2						DAS 8 9-89
					134118		2						DAS 8 9-89
D3955-5		Manufactured	No			110	Each	0.0000	2	24			DAS 8 9-89
D3955-5													
Plate													
D3955-7		Manufactured	No			110	Each	19.0000	6	6			DAS 8 9-89
D3955-7													
Plate													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST064			19						DAS 8 9-89
					144062		19						DAS 8 9-89

APR 19 2016



Picklist Print

April 11, 2016 8:11:15 AM

Page 2

Work Order ID: 144263

Parent Item: DSI 9464-011

Parent Item Name: Skidtube Tuning

144263

DSI 9464-011

Start Date: 4/11/2016

Required Date: 4/19/2016

Start Qty: 1.00

Required Qty: 1.00

D3955-21

Manufactured No

110

Each

2.0000

2 2

D3955-21

Gasket

DAS
28
9-89

Location

Loc Qty

Loc Code

ST064

2

134121

2

**

144263

D3955-23

Manufactured No

110

Each

2.0000

2 2

D3955-23

Template

DAS
28
9-89

Location

Loc Qty

Loc Code

ST064

2

134122

2

**

144263

CR3212-4-04

Purchased No

110

Each

319.0000

38

CR3212-4-04

Cherry Rivet

DAS
28
9-89

Location

Loc Qty

Loc Code

CCK005

100

m133077

100

LG001

40

m126534

40

ST320

179

m132317

17

m134365

162

**

2
38 26

70

APR 19 2016



Picklist Print

April 11, 2016 8:11:16 AM

Page 3

Work Order ID: 144263

144263

Parent Item: DSI 9464-011

DSI 9464-011

Parent Item Name: Skidtube Tuning

Start Date: 4/11/2016

Required Date: 4/19/2016

Start Qty: 1.00

Required Qty: 1.00

AN3-5A Purchased No

110 Each

382.0000

4

**

DAS
8
285

AN3-5A

Bolt

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

26

m133686

2

m134055

24

ST350

356

m134055

56

m134502

300

AN3-6A Purchased No

110 Each

178.0000

4

**

DAS
8
280

AN3-6A

Bolt

DAS
28
9-89

Location

Loc Qty

Loc Code

over003

75

M134630

75

ST349

103

M133932

1

M134055

102

AN3-7A Purchased No

110 Each

390.0000

4

**

DAS
8
289

AN3-7A

Bolt

DAS
28
9-89

Location

Loc Qty

Loc Code

over003

350

m133694

100

m134606

250

ST349

40

m132763

34

m132803

6

APR 19 2016

Picklist Print

April 11, 2016 8:11:16 AM

Page 4

Work Order ID: 144263

144263

Parent Item: DSI 9464-011

DSI 9464-011

Parent Item Name: Skidtube Tuning

Start Date: 4/11/2016

Required Date: 4/19/2016

Start Qty: 1.00

Required Qty: 1.00

AN3-10A

Purchased

No

110

Each

272.0000

4

18

AN3-10A

Bolt

**

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

1

m132763

1

over003

100

m134249

100

ST349

171

m133992

71

m134573

100

8

NAS1149D0332J

Purchased

No

110

Each

1,712.000

6

12

NAS1149D0332J

Washer

**

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

CA

6

m129682

6

GA

98

m132677

98

ST260a

1000

m134502

1000

ST264

583

m133988

583

ST266

25

m133498

25

1.2

APR 19 2016



Picklist Print

April 11, 2016 8:11:16 AM

Page 5

Work Order ID: 144263

144263

Parent Item: DSI 9464-011

DSI 9464-011

Parent Item Name: Skidtube Tuning

Start Date: 4/11/2016

Required Date: 4/19/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

110

Each

1,979.000

2

MS21042L3

Nut

**

Location

Loc Qty

Loc Code

FP001

100

m133790

100

GA

792

m133790

6

m134360

786

Return2016

1

M132382

1

ST304

1086

m134039

12

m134360

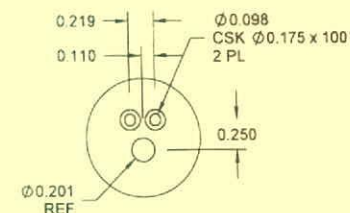
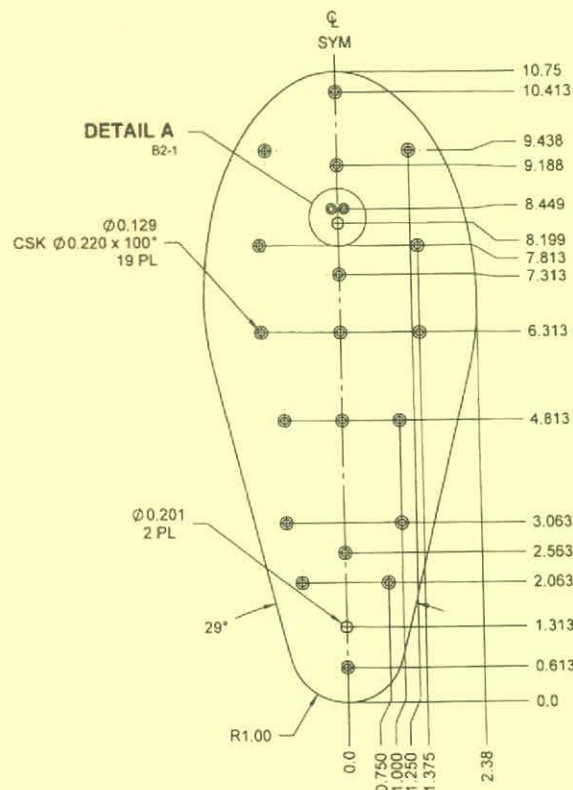
1074

DSI
28
9-89

DSI
27
9-89

APR 19 2016

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3955-041	DOUBLER ASSY
2	1	D3955-1	DOUBLER
3	1	MS21086L3	NUT PLATE
4	2	MS20427M3-3	RIVET



DETAIL A
SCALE 2X

D3955-041 DOUBLER ASSEMBLY

D3955-1 DOUBLER

D3955-1 NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.063 THICK SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N "D3955-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.25 lbs

A	NEW ISSUE	RF	09.07.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN	RF		
CHECKED			
MFG. APPR			
APPROVED			
DE APPR			
DATE	09.07.21		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3955

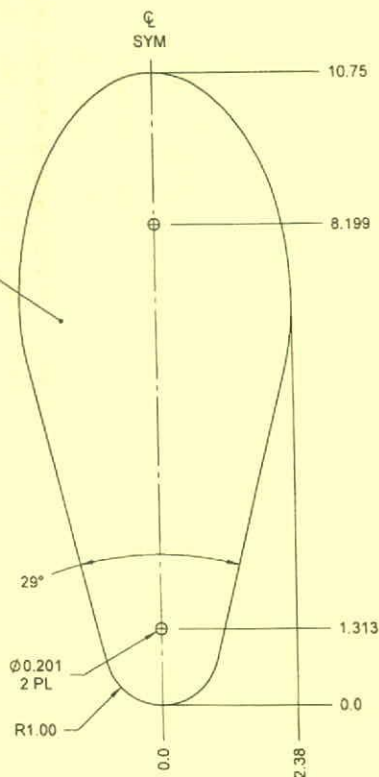
TITLE
SKIDTUBE TUNING KIT

REV. A
SHEET 1 OF 5
SCALE
NTS

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20160411
SEA 144763
RELEASED
09/07/22

APPLY ANTI-SKID
ON ONE SIDE ONLY



0.060 REF



D3955-3 COVER PLATE

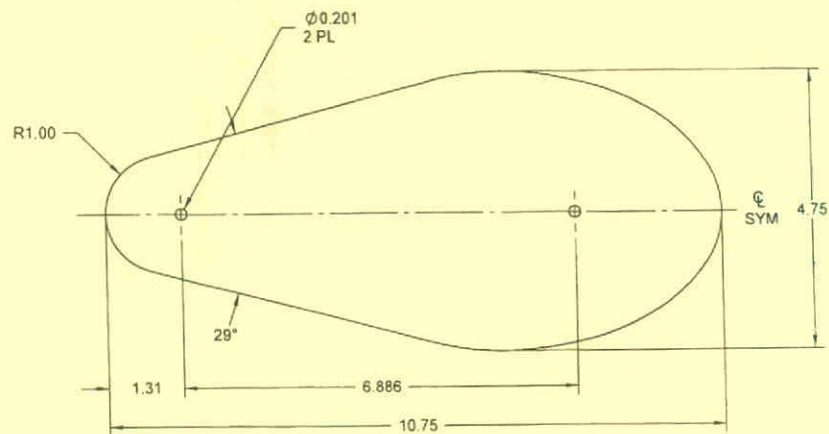
RELEASED
09/07/21

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.060 (16 GA) THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.64 lbs

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3955	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE TUNING KIT	NTS
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D3955-X PLATE

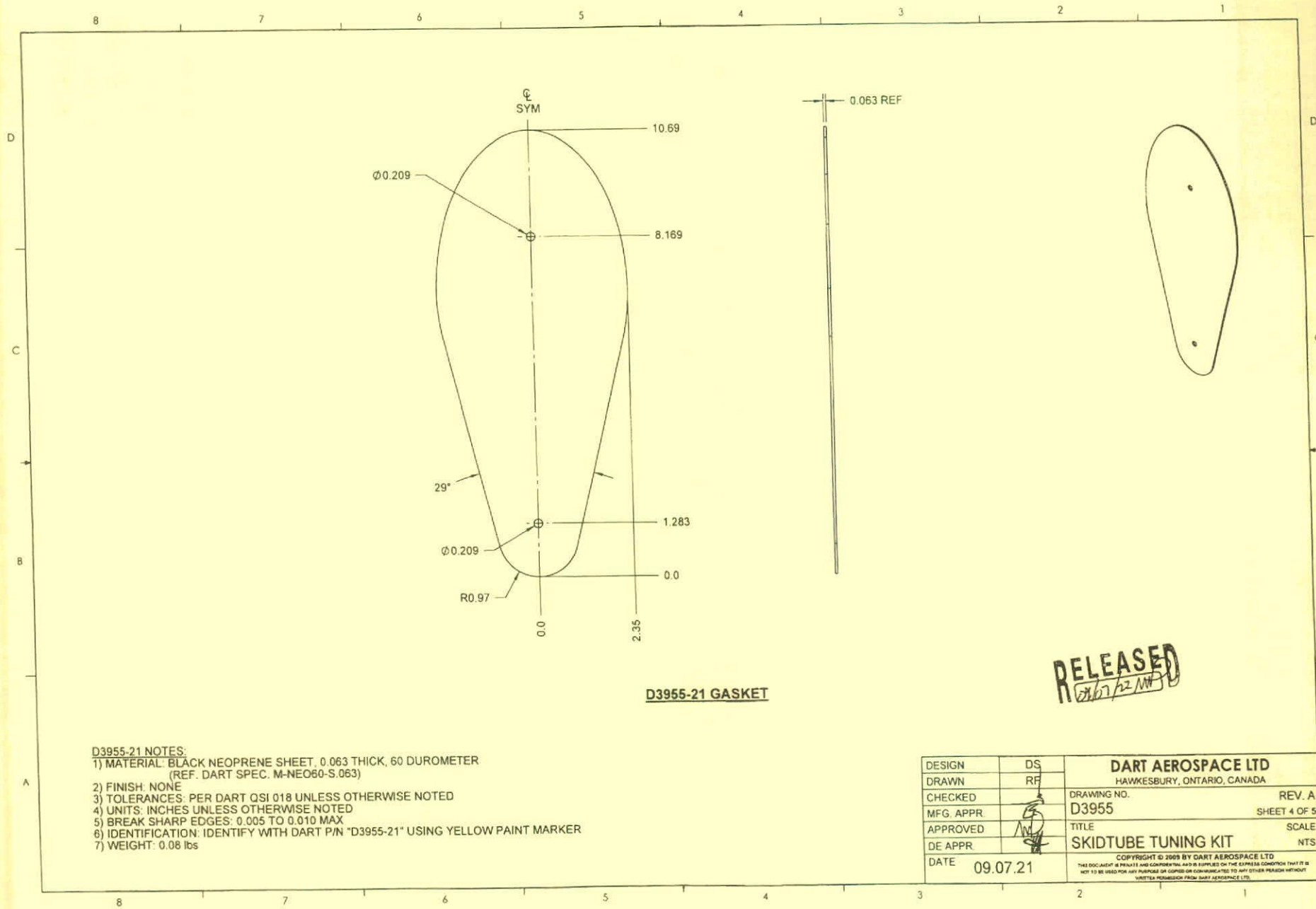
General Table			
P/N	T (in)	T (GA)	WEIGHT (lbs)
D3955-5	0.060	16	0.64
D3955-7	0.120	11	1.28

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, T (GA) THICK (REF. DART SPEC. M304ST'GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: SEE TABLE

RELEASED
09/07/21 MJD

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DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3955	SHEET 3 OF 5
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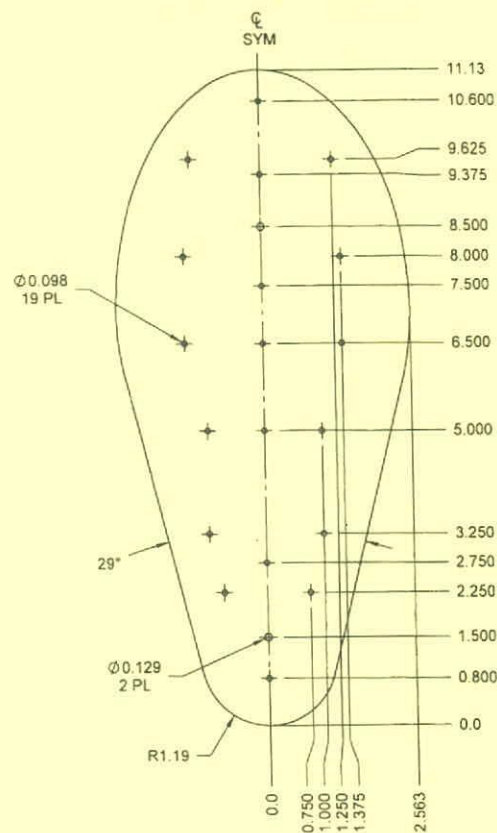
D3955-21 GASKET

RELEASED
 07/07/22 MW

D3955-21 NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 0.063 THICK, 60 DUROMETER
 (REF. DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-21" USING YELLOW PAINT MARKER
- 7) WEIGHT: 0.08 lbs

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3955	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE TUNING KIT	NTS
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D3955-23 TEMPLATE

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.040 THICK SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.040)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-23" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.16 lbs

RELEASED
2017/12/14

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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3955	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE TUNING KIT	NTS
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DART SERVICE INSTRUCTION

TO AMEND:
INSTALLATION INSTRUCTIONS D205-634 REV. F OR EARLIER,
INSTALLATION INSTRUCTIONS D204-635 REV. F OR EARLIER,
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-634 REV. 3 OR EARLIER,
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D204-635 REV. 3 OR EARLIER

REF CANADIAN STC: SH96-88
REF FAA STC: SR00563NY
REF EASA STC: EASA.IM.R.S.01303

Purpose:

The Purpose of the DSI 9464-011 Kit is to allow operators to tune landing gear utilizing D205-634-041 / D204-635-041 skidtubes in order to eliminate vibration. This kit consists of various weights that can be attached to the fwd cap of the Dart skidtube.

Procedure:

Note: Installer must be careful not to damage underlying skidtube during drilling operations.

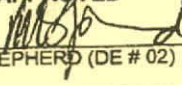
- 1) Locate D3955-23 template on the fwd cap of the skidtube. Transfer drill 19 x Ø0.098" holes from the D3955-23 template to the skidtube cap using a #30 drill.
- 2) Transfer drill 1 x Ø0.625" (15.8 mm) from the D3955-23 template to the skidtube as shown in Figure 1.
- 3) Transfer drill 1 x Ø0.201" (#7 drill) from the D3955-23 template to the skidtube as shown in Figure 1.
- 4) Deburr the drilled holes in fwd cap. Ensure the top surface of the cap is clear of debris.
- 5) Apply a layer of Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 Class B2 sealant between the D3955-041 Doubler and the existing skidtube cap. Install D3955-041 Doubler Assy. using 19 x CR3212-4-04 rivets as shown in Figure 1. The nutplate in the D3955-041 Doubler Assy should pass thru the Ø0.625 hole in the cap.
- 6) Install tuning plates as shown in Figure 2. Torque AN3 bolts 15-25 in-lb (1.7-2.8 N-m). Test the landing gear for vibration.
- 7) If vibration persists, repeat step 6 until vibration is eliminated.
- 8) Update Weight & Balance as outlined below.

Weight And Balance:

The weight and balance increase associated with the installation of the DSI 9464-011 kit will depend on the number of plates that are installed to tune the gear. The weight of individual plates are given in the Parts List Table. The longitudinal arm for the installation of the DSI 9464-011 kit is 40.0 in (1.02 m) on 205/210/212/214/412 models and 42.0 in (1.07 m) on 204 models.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 10.04.14
CERT. NO.: SH96-88
ISSUE NO.: 3

20160411 SA 144263

B	ADD REF TO D204-635	CP	10.04.14
A	NEW ISSUE	RF	09.07.21
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		DSI 9464	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE TUNING KIT	NTS
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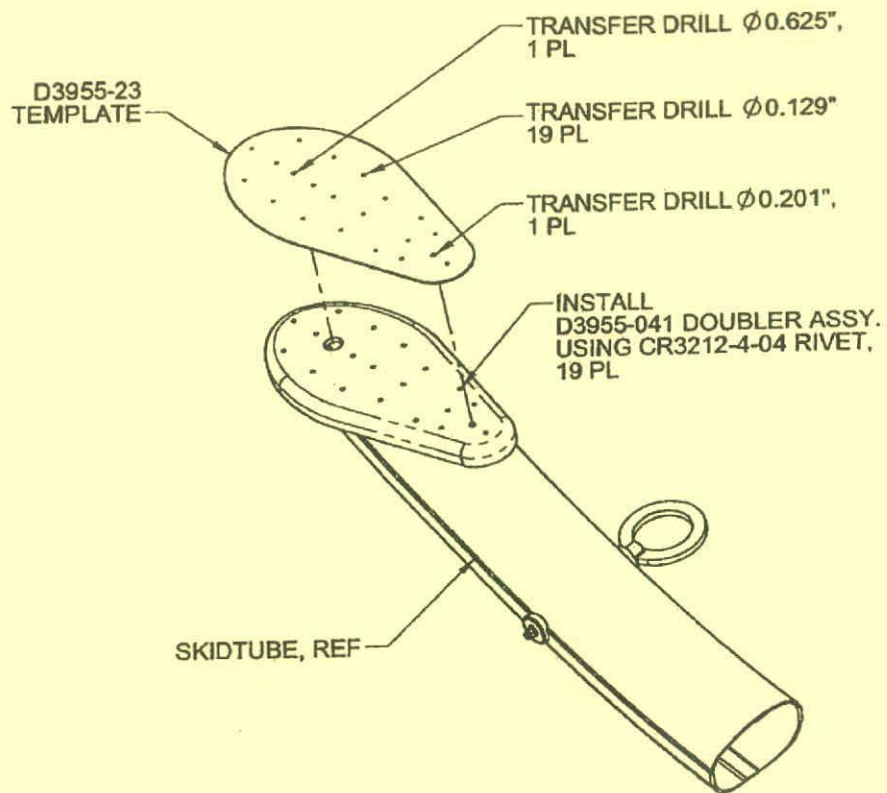


Figure 1

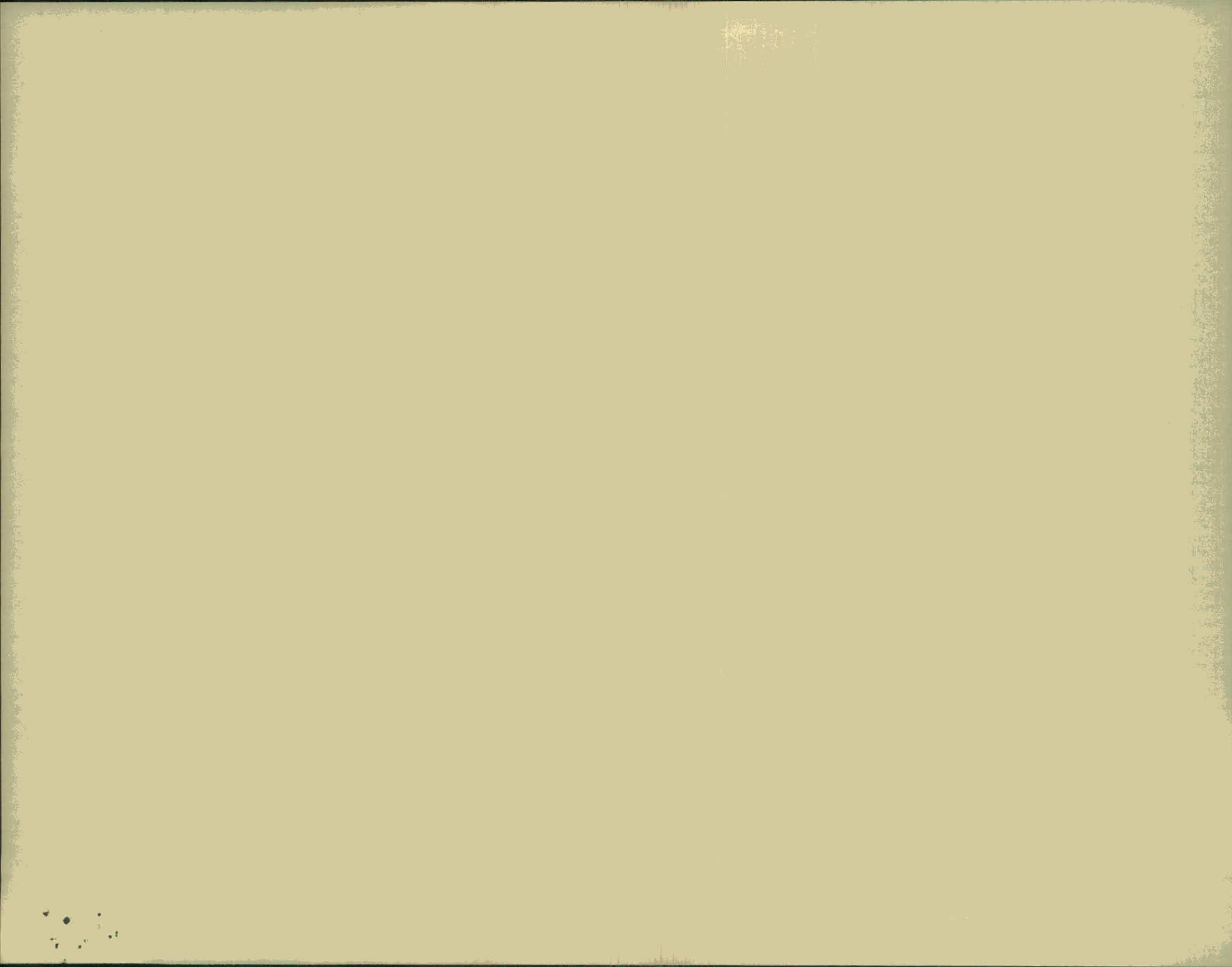
CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.04.14
CERT. NO.: SH96-88
ISSUE NO.: 3

DESIGN	RF	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9464	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE TUNING KIT	NTS
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Part List

Qty -011	Part Number	Description	Weight
X	DSI 9464-011	SKIDTUBE TUNING KIT	N/A
2	D3955-041	DOUBLER ASSEMBLY	0.25 lb/ 0.11 kg
2	D3955-3	COVER PLATE	0.64 lb/ 0.29 kg
2	D3955-5	0.063" THICK PLATE	0.64 lb/ 0.29 kg
6	D3955-7	0.125" THICK PLATE	1.28 lb/ 0.58 kg
2	D3955-21	GASKET	0.08 lb/ 0.04 kg
2	D3955-23	TEMPLATE	N/A
38	CR3212-4-04	RIVET	N/A
4	AN3-5A	BOLT	N/A
4	AN3-6A	BOLT	N/A
4	AN3-7A	BOLT	N/A
4	AN3-10A	BOLT	N/A
6	NAS1149D0332J	WASHER	N/A
2	MS21042L3	NUT (OR MS21042-3)	N/A

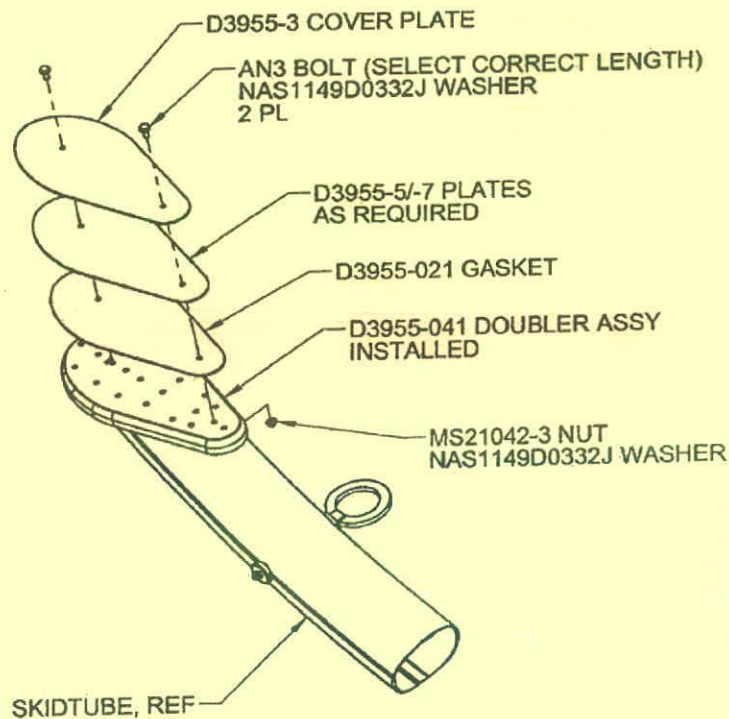


Figure 2

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.04.14
CERT. NO.: SH96-88
ISSUE NO.: 3

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	<i>GP</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9464	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SKIDTUBE TUNING KIT	NTS
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~~Work~~ Order ID 144400

April 14, 2016 3:37:57 PM

144400

Page 1

Item ID: D206-836-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Crosstube Antenna Mount 206 A/B AFT & 206A/B/L FWD

Start Date: 4/18/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/21/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

JK

Date:

20160413

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

GA202-2

A

DAS

6

BBC

100

Document Control

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels as per PPP D206-836-011 CH001

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

APR 15 2016

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.12

Quality Control

REFERENCE ONLY

Part List

Qty -011	Part Number	Description	Weight
X	DSI 9464-011	SKIDTUBE TUNING KIT	N/A
2	D3955-041	DOUBLER ASSEMBLY	0.25 lb/ 0.11 kg
2	D3955-3	COVER PLATE	0.64 lb/ 0.29 kg
2	D3955-5	0.063" THICK PLATE	0.64 lb/ 0.29 kg
6	D3955-7	0.125" THICK PLATE	1.28 lb/ 0.58 kg
2	D3955-21	GASKET	0.08 lb/ 0.04 kg
2	D3955-23	TEMPLATE	N/A
38	CR3212-4-04	RIVET	N/A
4	AN3-5A	BOLT	N/A
4	AN3-6A	BOLT	N/A
4	AN3-7A	BOLT	N/A
4	AN3-10A	BOLT	N/A
6	NAS1149D0332J	WASHER	N/A
2	MS21042L3	NUT (OR MS21042-3)	N/A

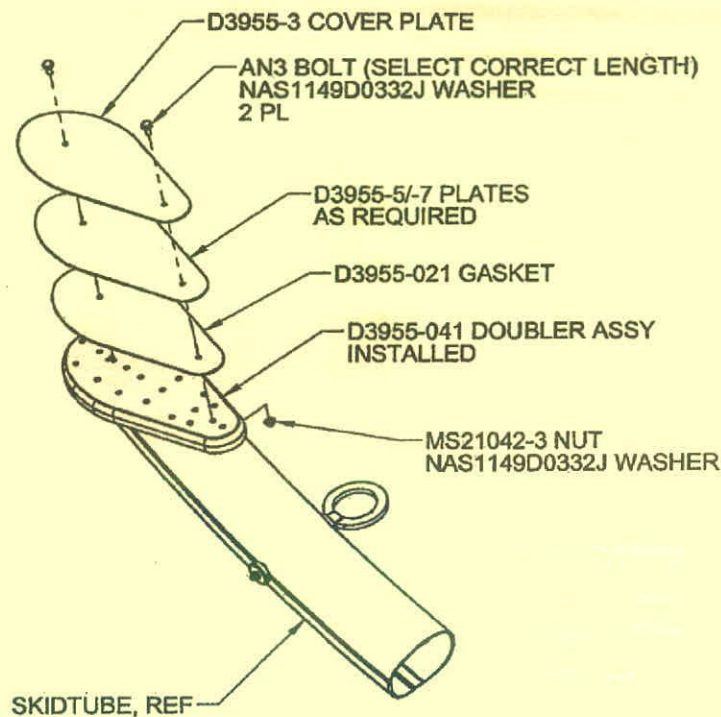


Figure 2

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.04.14
CERT. NO.: SH96-88
ISSUE NO.: 3

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	gp	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9464	SHEET 3 OF 3
APPROVED	1/14	TITLE	SCALE
DE APPR.	1/14	SKIDTUBE TUNING KIT	NTS
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